

Work Order ID 58205 -1

Thursday, April 29, 2010 10:36:43 AM

Page 1

Item ID: D3637-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 4/29/2010 Start Qty: 10.00

Required Date: 5/14/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: MF

QC:

Date: 10-4-09

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100



Waterjet

FLOW WATER JET

0.00

FLOW CNC Waterjet

304 .080

Memo

0.00

1-Cut as per Dwg D3637
Deburr if necessary

Dwg Rev: B

Prog Rev: B

2-

B10-4-09

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B10-4-09

(14)

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5/10/09

104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3637

0.00

0.00

SB 10/04/03

14

8

140



Small Fab

Small Fab

Small Fab

Memo

1- drill holes as per dwg using DT8979 2-C Sink as per Dwg D3637 3-
Install Nut plate as per Dwg D3637

0.00

0.00

=> m. k w/05/10

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5/06/10

(42)

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

PIP 58489

0.00

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/05/10

(2)

10/05/10

ME 10-5-10

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Picklist Print

Thursday, April 29, 2010 10:36:42 AM

Page 1

Work Order ID: 58205

Parent Item: D3637-041

Parent Item Name: Bracket Assembly

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Start Date: 4/29/2010

Required Date: 5/14/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			100	Each	5,068.000	2			
Rivet												

M304S14GA



304SS sheet 080

Purchased

No

Location

ST316

19099

7681 ✓

Loc Qty

5068

4774

294

140

sf

Loc Code

138.6608

0.09

28 m-k 10/05/10

2.0

1310-4-28

(14)

Location

MAT20

113295

Loc Qty

138.6608

138.6608

140

Each

Loc Code

37.0000

1

113.075

MS21059L4



Nutplate

Purchased

No

Location

ST302

112243 ✓

Loc Qty

37

37

Loc Code

14x m-k

10/05/10

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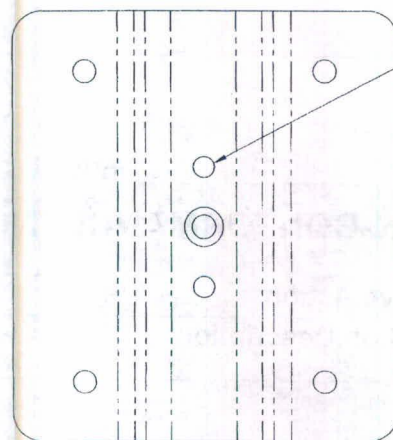
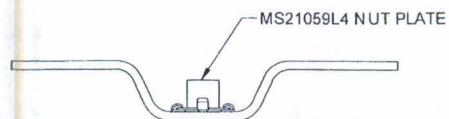
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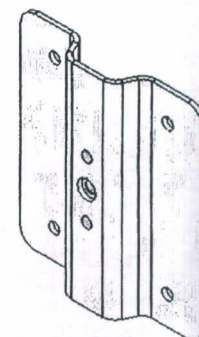
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MS20426AD3-3 RIVET
(2 PLACES)



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS		
DRAWN	LE		
CHECKED	PA		
MFG. APPR.	EP		
APPROVED	W		
DE APPR.	H		
DATE	07.12.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3637** REV. B
TITLE **BRACKET** SCALE 1:1

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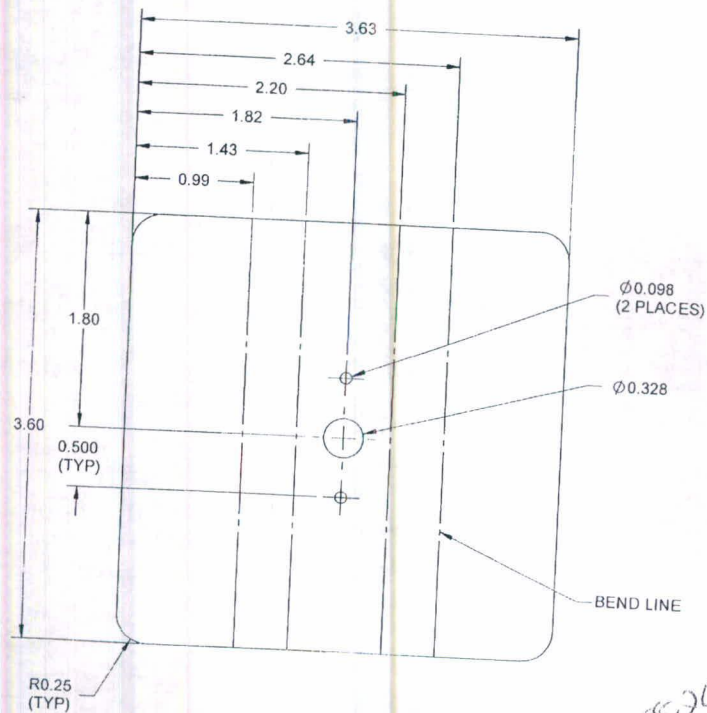
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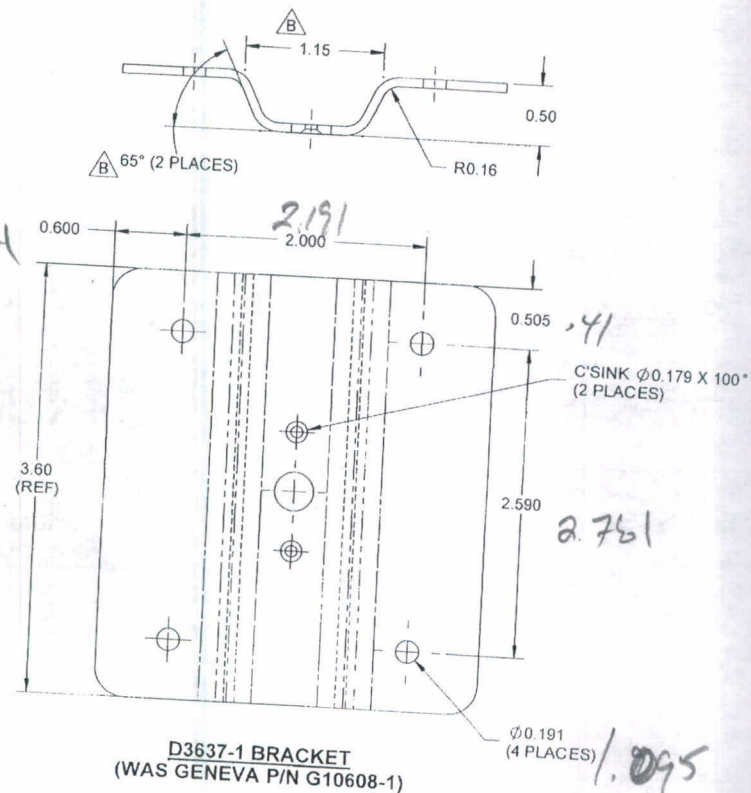
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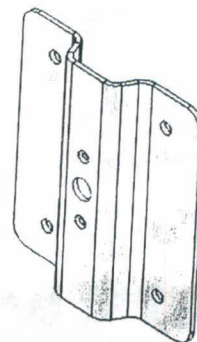
NOTE: Date & initial all entries



D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



D3637-1 NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3637	
APPROVED	LE	TITLE	SHEET 2 OF 3
DE APPR.	LE	BRACKET	SCALE
DATE	07.12.18		1:1

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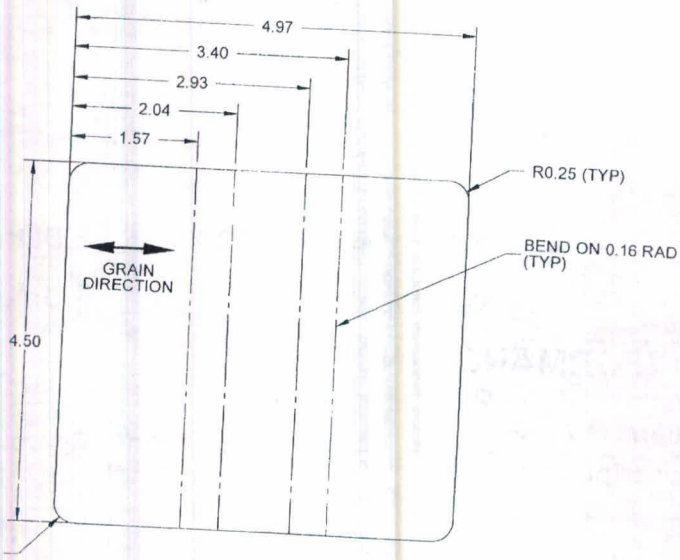
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

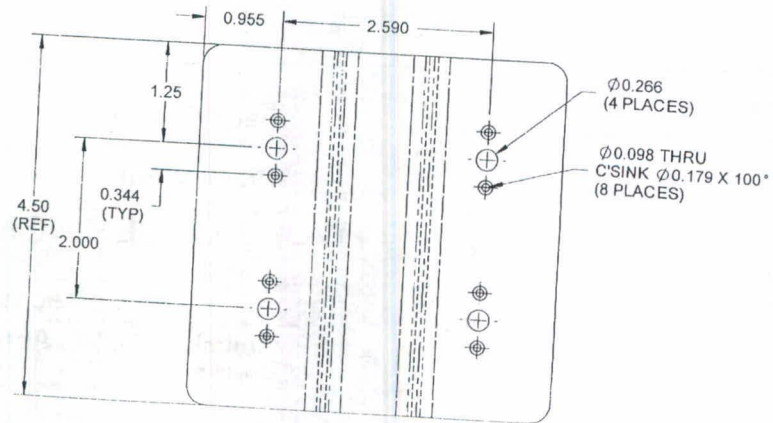
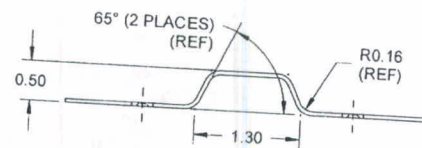
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8 7 6 5 4 3 2 1

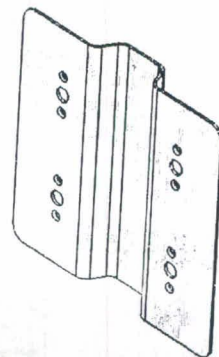


D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**

#58203



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

8 7 6 5 4 3 2 1

DESIGN	TS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE	DRAWING NO.	REV. B
CHECKED	PA	D3637	SHEET 3 OF 3
MFG. APPR.	CF	TITLE	SCALE
APPROVED	W	BRACKET	2:3
DE APPR.		DATE 07.12.18	
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